

# Work Order ID 86604

\*86604\*

Page 1

Thursday, July 05, 2012 3:26:10 PM

Item ID: D3608-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Lower Doubler

Stop \*NS2\*

Start Date: 7/5/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 7/12/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference: REWORK TO POLISH

Approvals: Process Plan: *mf*

Date: 12-07-05

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3608

C

170

0.00

\*170\*

QC

Memo

0.00

Quality Control

PULL FROM STOCK D3608-1 X 6 B78850

*CX 12/07/17*

180

Outsource process - Electrochemically polish

0.00

\*180\*

Outsource6

Memo

0.00

Outsource process - Electrochemical

SEND TO TQF FOR ELECTROPOLISHING

*P/O: 17481  
CP Tech*

*CX 12/07/17 8*

190

Receive & Inspect for Damage & Mat'l Certs

0.00

\*190\*

Packaging

Memo

0.00

Packaging

*CX 12/11/27 (8)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86604

\*86604\*

Page 2

Thursday, July 05, 2012 3:26:10 PM

Item ID: D3608-1

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Lower Doubler

Stop \*NS2\*

Start Date: 7/5/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 7/12/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference: REWORK TO POLISH

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

\*200\*

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: 175

0.00

\*210\*

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

Memo

0.00

Quality Control

DAS  
16  
9-89 12/4/13

(x8)

812

12/3/23

12/7/30

mf  
12-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 05, 2012 3:26:10 PM

Page 1

Work Order ID: 86604  
Parent Item: D3608-1  
Parent Item Name: Lower Doubler

Start Date: 7/5/2012

Required Date: 7/12/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-26 JLM  
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC  
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP Rev:D 10.02.16 rev.B as  
per dwg DD verified by:EC IPP Rev:E 10.11.17 as per PC1 dwg DD verified by:EC IPP  
Rev:F 10.11.29 as per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3608-1 Lower Doubler		Manufactured	No				Each	0.0000		6		6/21/12	

6 x 78850  
MF  
12-07-05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO17481

Purchase Order Date 7/18/12

PO Print Date 7/19/12

Page Number 1 of 1

Order From : VC-WEM001  
WATERLOO ELECTROPLATING & METAL FINISHING INC.  
105 RANDALL DRIVE  
WATERLOO, ONTARIO N2V 1C5  
CANADA

Contact Name  
Vendor Phone 519-884-0797  
Vendor Fax 519-884-4937  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	86605	D3608-3 UPPER DOUBLER	7/27/12 Yes	7.00	FedEx PI collect	\$30.0000	\$210.00
		Special Inst: ELECTROPOLISH AS PER BAPS 160-036					
	86604	D3608-1 LOWER DOUBLER	7/27/12 Yes	8.00	FedEx PI collect	\$30.0000	\$240.00
		Special Inst: ELECTROPOLISH AS PER BAPS 160-036					
3	86607	D3609-1 FUEL PANEL	7/27/12 Yes	3.00	FedEx PI collect	\$25.0000	\$75.00
		Special Inst: ELECTROPOLISH AS PER BAPS 160-036					
PO Total:							\$525.00

Change Nbr: 3

Change Date: 7/19/12

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required - YES NO

# Waterloo Electroplating & Metal Finishing Inc.

*We bring excellence to the surface*

## CERTIFICATE OF COMPLIANCE

**Issued to:** Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

**Date:** July 26, 2012  
**P.O. #** PO17481

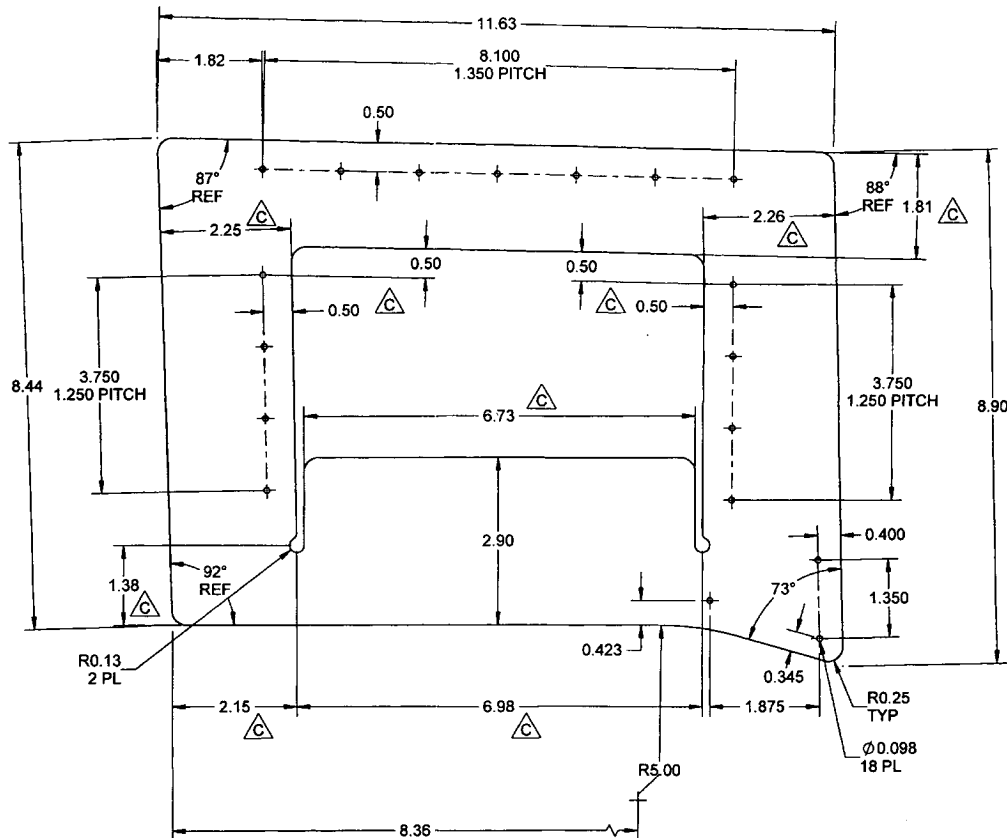
This is to certify that the items listed below have been processed and finished in compliance to the specifications in the contract or purchase order.

Part #	Description	Qty	Specification
86605	D3608-3 Upper Doubler	7	Electropolish BAPS 160-036
86604	D3608-1 Lower Doubler	8	Electropolish BAPS 160-036
86607	D3609-1 Fuel Panel	3	Electropolish BAPS 160-036

For and on behalf of  
WATERLOO ELECTROPLATING  
Q. C.

*Shakil Ahsan*





RELEASED  
2010-11-23

# **D3608-1 LOWER DOUBLER**

## **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE  
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)  
OR ASTM A240 OR ASTM SA240  
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 (C)
- 7) WEIGHT: 0.76 lbs

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	MB	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F/3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.19		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3608** REV. C  
SHEET 1 OF 2

TITLE **DOUBLER** SCALE NTS

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